

Date: Friday, 16/05/2008 8:45:46 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BAR
Job Number :	39319		
Estimate Number :	10386		
P.O. Number :		Part Number :	D31961
This Issue :	16/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3196 REVC
First Issue :	//	Project Number :	N/A
Previous Run :	31466	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :	<u>JUL 08.5.14</u>	Due Date :	06/06/2008
Comment :	Est Rev: A New Issue 05-11-08 JLM	Qty:	10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
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Comment: Qty.: 2.2922 f(s)/Unit Total: 22.9215 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)
 (M6061T6B0.750x01.500)
 Identify for D3196-1
 Batch: M106118

(10)

mmr 08/05/24

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blank: (0.75" x 1.50") x 26.200" long Bar

mmr 08/05/24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-1 as per Folio FA339 and Dwg D3196 Identify as D3196-1

2-Deburr

J.L 08/05/31

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/05/31

5.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

20 08/06/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/05/2008 8:45:46 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 39319

Part Number: D31961

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



10X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1/2B 08/06/02

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:50

OVEN TEMPERATURE:

320°

FINISH TIME:

9:20

10. 08-06-03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



42

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-03

(X16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57247 08-06-03 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39319
Description: Bar		Part Number: D3196-1
Inspection Dwg: D3196	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.094	+/-0.010	26.094	✓			
4.045	+/-0.010	4.043	✓			
18.003	+/-0.005	18.003	✓			
0.750	+/-0.005	0.749	✓			
1.500	+/-0.010	1.497	✓			
Ø0.344	+0.006/-0.001	0.346	✓			
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	0.663 x 100°	✓			
0.060 x 45°	+/-0.010 x 0.5°	0.065 x 45°	✓			
0.750	+/-0.010	0.748	✓			
0.250	+/-0.010	0.242	✓			
3.495	+/-0.010	3.486	✓			
9.000	+/-0.010	8.990	✓			
16.844	+/-0.010	16.835	✓			
21.498	+/-0.010	21.489	✓			
R0.125	+/-0.010	0.125	✓			
1.1 00	+/-0.010	1.091	✓			
R0.125	+/-0.010	0.125	✓			
0.444	+/-0.010	0.442	✓			

Measured by: JL	Audited by: RY	Prototype Approval: N/A
Date: 08/05/31	Date: 08/06/01	Date: N/A

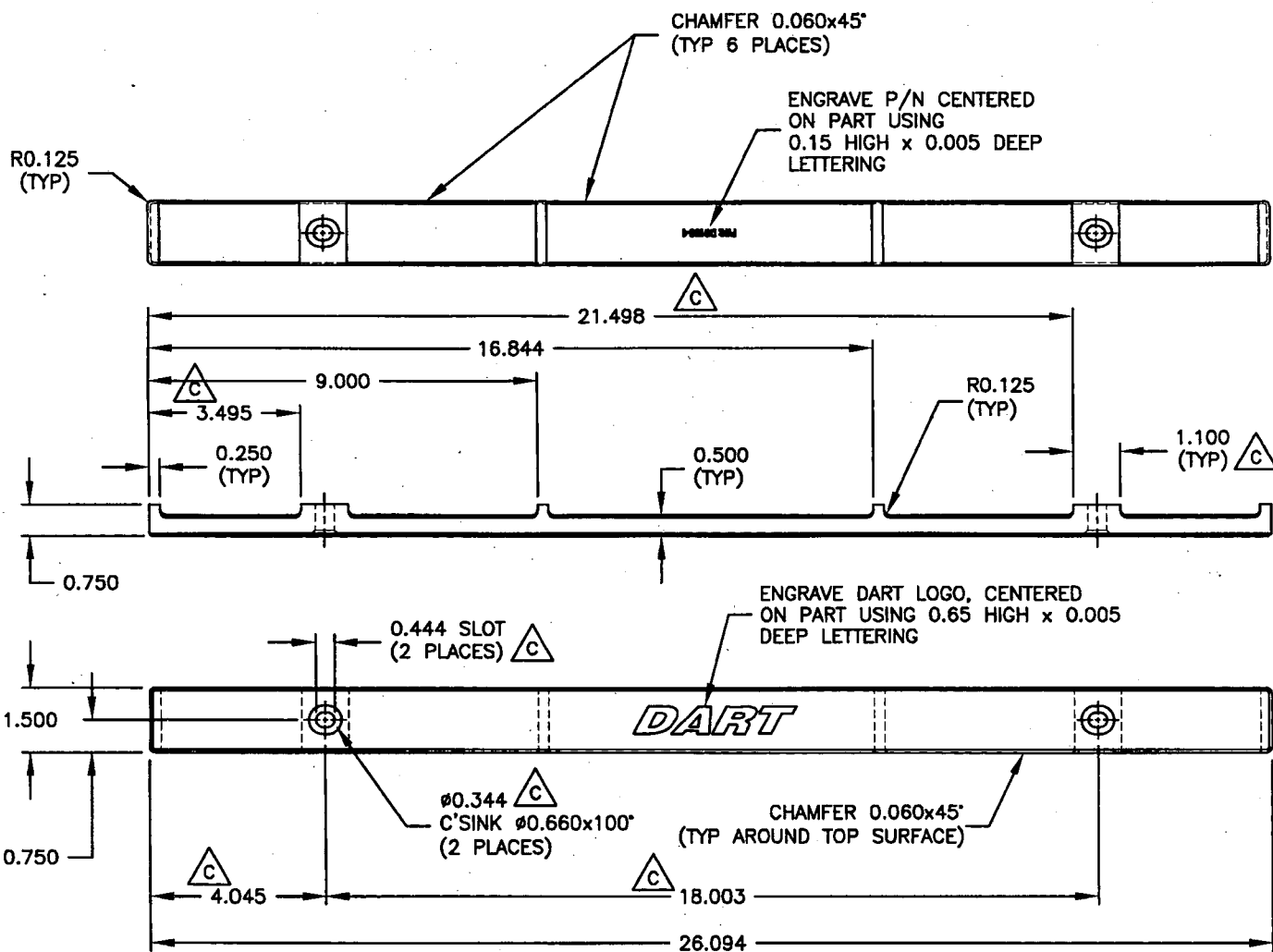
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM	
C	07.03.21	Dimensions updated per Dwg rev. C	KJ/JLM	BE

DART

RELEASED

06.10.31

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
06.10.31	03.06.25	NEW ISSUE	
06.09.25	ADD D3196-5		
06.10.31	ADD SLOTS ON -1; REMOVED -5		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
06.10.31	06.10.31	D3196	
DATE	TITLE	SCALE	
06.10.31	BAR	1:4	

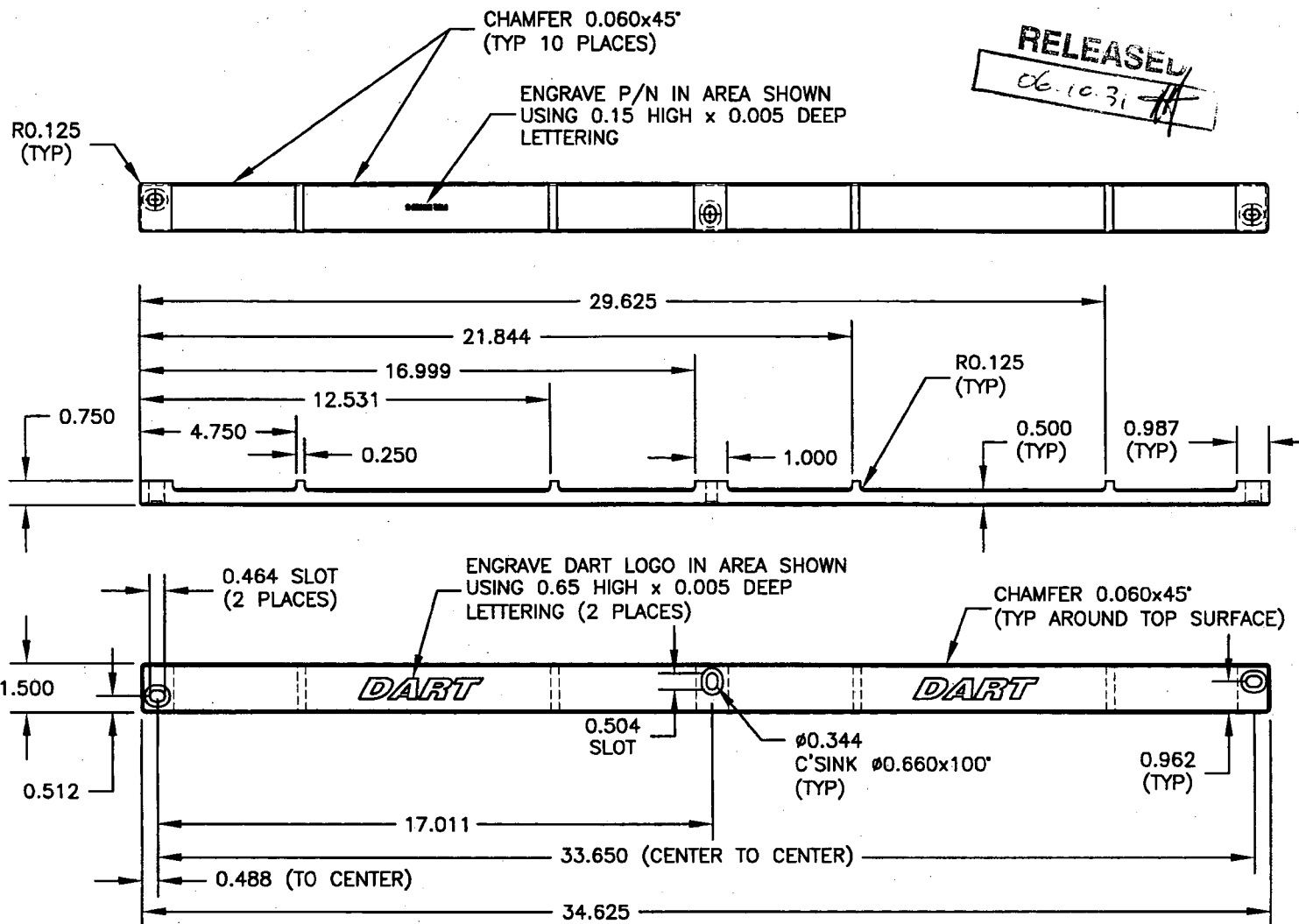
**D3196-1 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 39319

DART

RELEASED
06.10.31



D3196-3 BAR

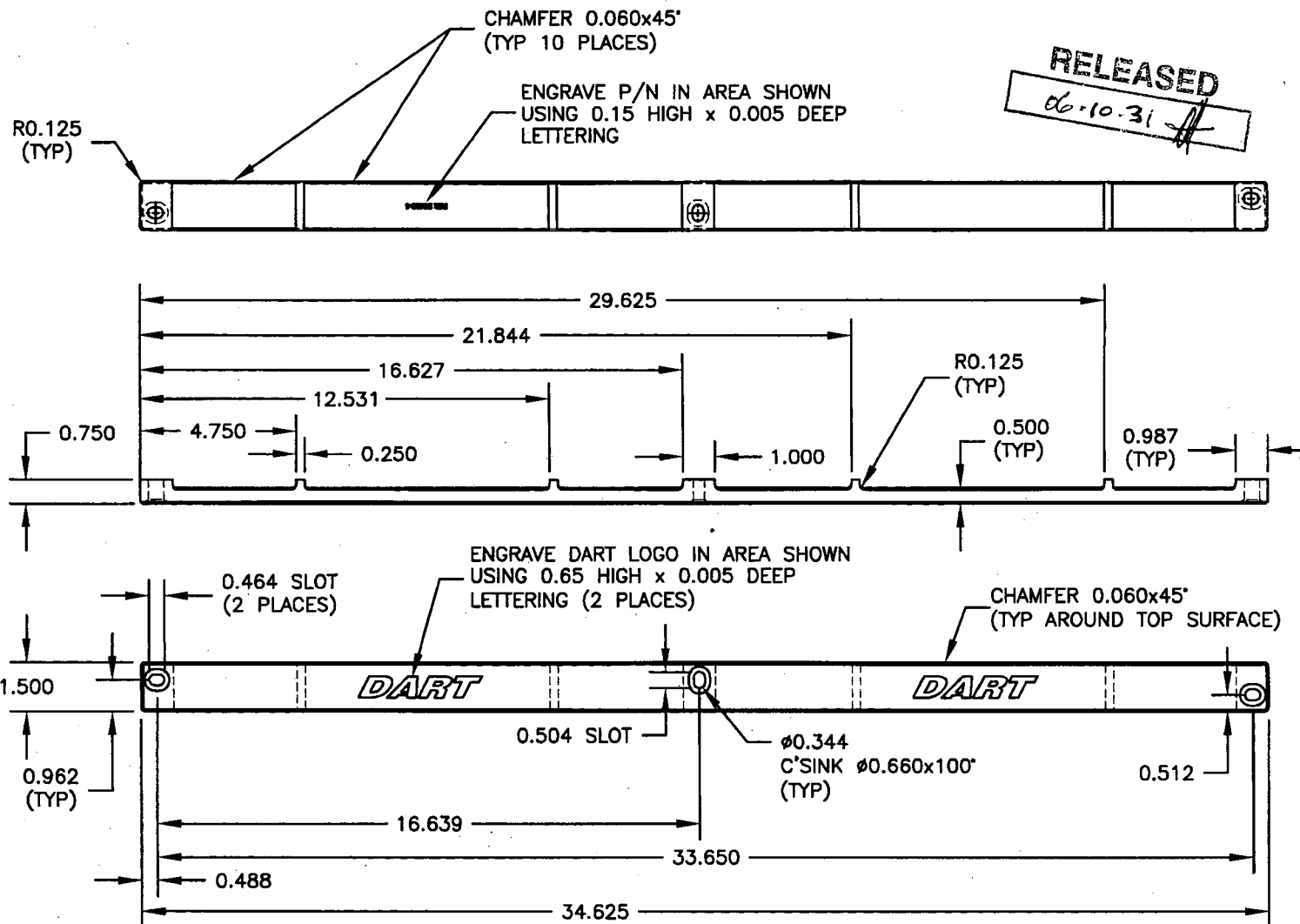
- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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NO. 38319

DESIGN	Q9	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	PH	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA
DATE	06.10.31	TITLE	BAR	REV. C
		DRAWING NO.	D3196	SHEET 2 OF 3
		SCALE	1:5	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED PH	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE 06.10.31	DRAWING NO. D3196	REV. C
	TITLE BAR	SHEET 3 OF 3
	SCALE 1:5	



D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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